

Date: Tuesday, 15/08/2006 7:17:12 AM
 User: Linda Lacelle

Process Sheet

SPLIT 06/09/07

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET ASSEMBLY			
Job Number	: 28159						
Estimate Number	: 11033						
P.O. Number	: N/A			Part Number	: D2803044		
This Issue	: 15/08/2006	S.O. No. : N/A			Drawing Number	: D2803 REV B	
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: N/A		Type	: PURCHASED PARTS			
Previous Run	: N/A			Drawing Revision	: B		
Written By	: <u>JL</u>			Material	: N/A		
Checked & Approved By	: <u>JL</u>			Due Date	: 08/09/2006		
Comment	: Est D 05.03.30 MS21043-3 was MS21042L3			Qty:	8	Um: Each	
KJ/JLM							

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D28032	STA 84 Bracket	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) STA 84 BRACKET	B28180 4 B27302 4 B27684 3M4 X 06/08/31
		Pick: Qty Part Number Description Batch	
→	1 D2803- <u>2</u> <u>6</u>	Bracket	
2.0	D28054	Stop	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) STOP	B28183 06/08/31
		Pick: Qty Part Number Description Batch	
3	1 D2805- <u>B</u> <u>4</u>	Stop	B28183 06/08/31
3.0	D2809	Bushing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Bushing	
		Pick: Qty Part Number Description Batch	
	1 D2809	Bushing	B27617 ① B27617 V B28629 ② MF. 06/09/18 ③ 06/08/31
		Press D2805-4 into arm as per Dwg D2803	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date:

Tuesday, 15/06/2006 7:17:12 AM

User:

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 28159

Part Number: D2803044

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 *QC5*
QC5
06/09/18

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

88 06/09/18

8

5.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 06/09/18 ⑧

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf. 06/09/18 ⑧

7.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2803

mf. 06/09/18 ⑧

8.0 AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

2 AN3C16A Bolt

*101189 ✓**10/09/31*

9.0 MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch

2 MS21043-3 Nut

*119099 ✓**10/09/31*

10.0 (c) NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

4 NAS1515H3 Washer

100993

A/R LPS-3 Corrosion Spray

*101172 - mf.**06/09/18*

Form: rprocess

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
0609/13	105	Put LPS Hardcoat Corrosion Inhibitor on each washer. <u>217045</u>	MF.	06/09/13. (8)			
			8/2	0609/19			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/09/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 28159

Part Number: D2803044

Job Number:



Seq. #: Machine Or Operation:

Description :

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803

M101472

MF. 06/09/18

11.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2803.

MF. 06/09/18

12.0 QC5

INSPECT WORK TO CURRENT STEP



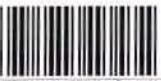
Comment: INSPECT WORK TO CURRENT STEP

SB 06/09/19

⑧

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ST161

BB 06/09/19 ①

SB 06/09/18

⑦

14.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/09/19

⑦

Job Completion



u 06/09/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

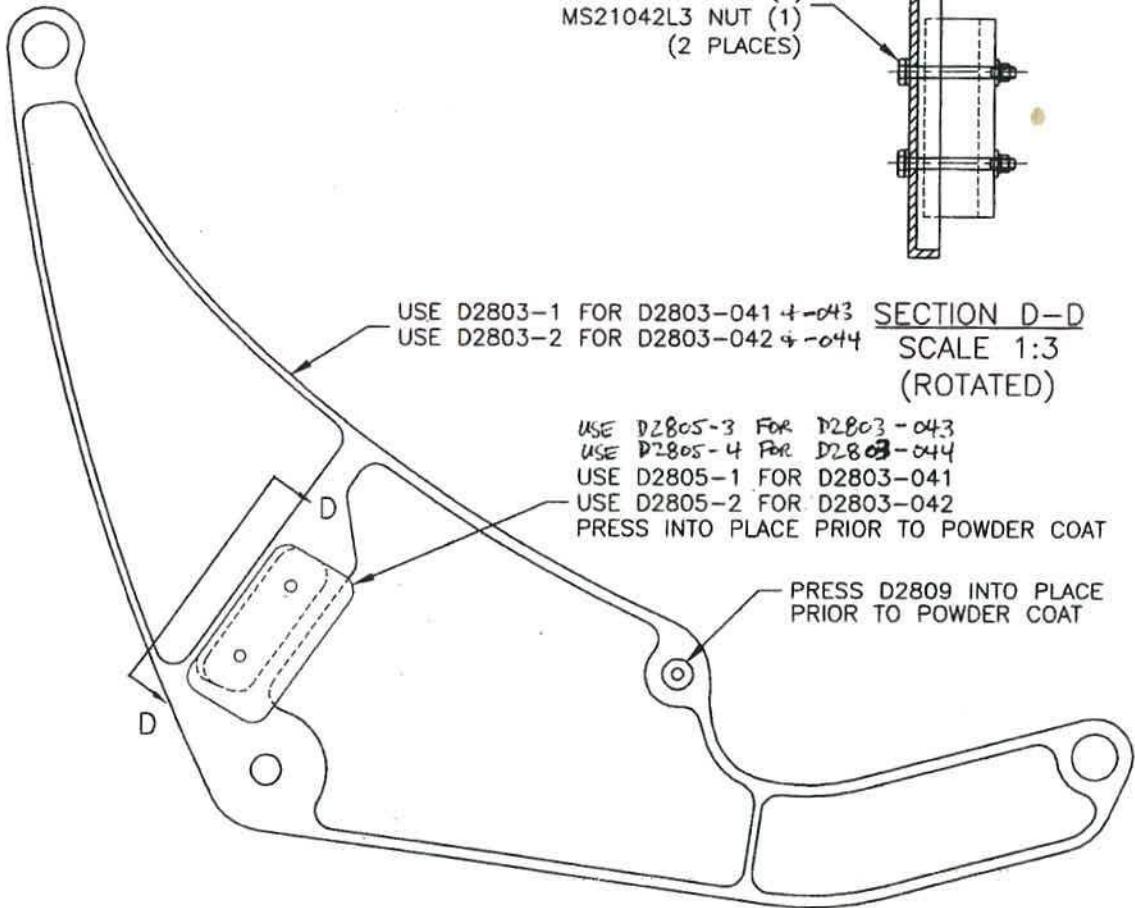
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D2803	SHEET 2 OF 2

RELEASED
00.11.07

FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY
SANDEX (4.3.5.6) OR BLACK SANDEX (4.3.5.7) OR GREEN SANDEX
(4.3.5.8) PER DART QSI 005 4.3